

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/02/2009 7:40:34 AM
 User: Melanie Fauteux

Process Sheet

TULMAR

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 45762
 Estimate Number : 13405
 P.O. Number :
 This Issue : 12/02/2009 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1/1 Type : SMALL / MED FAB
 Previous Run : 45076
 Written By :
 Checked & Approved By : MF 09-02-11
 Comment : Est Rev:A 08-06-20 new issue DD verified by:ec

Drawing Name : 90 DEGREE COVER PLATE
 Part Number : PB674300169
 Drawing Number : B6743001 PAGE25
 Project Number : N/A
 Drawing Revision : *Preln*
 Material :
 Due Date : 19/02/2009 Qty: 16 Um: Each

04.02.12
 POSITIVE RECALL

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6S032 6061-T6 Sheet 0.032"



Comment: Qty.: 1.4234 sf(s)/Unit Total: 22.7741 sf(s)
 6061-T6 Sheet 0.032" 11063 18 9-2-12

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET
 1-Cut as per Dwg B67-43001
 Dwg Rev: *E*
 Prog Rev: *E*

****grain direction along 9.144" ****

2-Deburr if necessary

18 9-2-12

18 9-2-12

(18)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE 18 9-2-12

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

09.02.12 18
 ENGINEERING APPROVAL
 04.02.12

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE
 Bend as per Dwg B67-43001

SA 09/02/12 (18)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09.02.17	8.0	CHANGE NOTE PER MARK UPS					

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Date: Thursday, 12/02/2009 7:40:34 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 90 DEGREE COVER PLATE

Job Number: 45762

Part Number: PB674300169

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.02.12 (18)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld assembly as per dwg B67-43001

09.02.17

SP 09.02.17

(18)

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- grind weld flush GRIND SHARP ~~WELDS~~ WELD BEADS

09.02.17

09.02.17

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

09.02.17

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.02.17

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

ACCEPTABLE TO DRILL & POLISH

Weld TO MARK PART

TO DET A) PER MARKING

BR 09-02-18 (18)

09.02.17

12.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Green Sandtex (Ref: 4.3.5.8) as per QSI 005 4.3

11.102316

START TIME:

2:30pm

OVEN TEMPERATURE:

320°F

FINISH TIME:

3:00pm

11

09-02-17

(18)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FR 09/02/17 (18)

W/O:		WORK ORDER CHANGES					
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

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Job Number: 45762

Part Number: PB674300169

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

PG

PURCHASING



Comment: PURCHASING

SEND TO TALMAR FOR FOAM AND FABRIC

3/0: 8208

09/02/17 (18)

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

09/3/4 (18)

16.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

ENGINEERING
APPROVAL

09/03/04

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST -

437

MF 09-03-05

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

18

09/03/06

Job Completion



POSITIVE RECALL

EFFECTIVE

09/03/04

AUTH

W

RELEASED

09/03/04

DATE

09/03/04

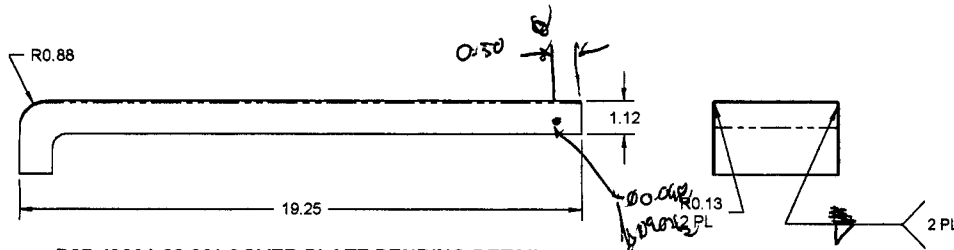


09/03/04

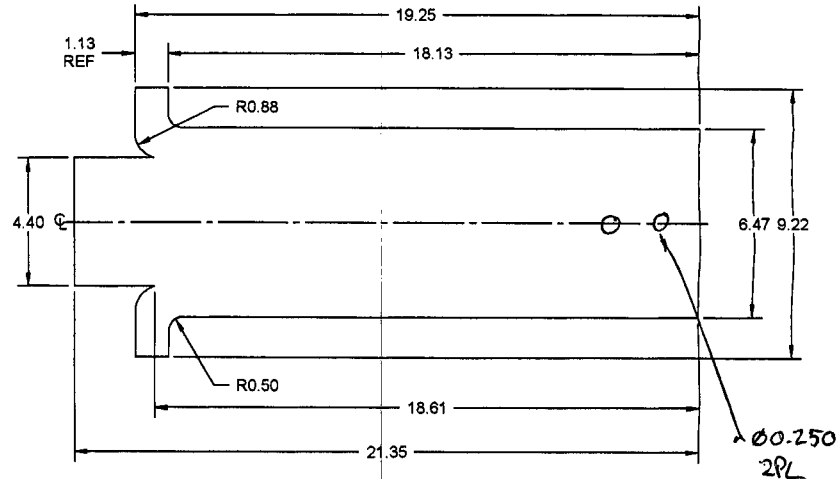
MF

09-03-05

PRELIMINARY ISSUE
02.02.12



B67-43001-69 90° COVER PLATE BENDING DETAIL
(MAKE FROM B67-43001-69F)



B67-43001-69F 90° COVER PLATE FLAT PATTERN

0.0250
2PL
To be
transferred
upon ASS'y

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.032 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027
REF. DART SPEC. M6061T6S 032
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-69" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.42 lbs

#45762

DESIGN	RW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		B67-43001-69	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.	N/A	90° COVER PLATE	NTS
DATE	09.02.11	COPYRIGHT © 1996 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

DB 6743001-69

<input checked="" type="checkbox"/>	First Article	<input checked="" type="checkbox"/>	Prototype
-------------------------------------	---------------	-------------------------------------	-----------

Measured by: <i>BS</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: <i>9-2-12</i>	Date: <i>009-02-12</i>	Date:

FORMS INFORMATION Assurance Approved OAI/FAI revD

PACKING SLIP

TULMAR

Tulmar Safety Systems Inc.
1123 Cameron Street
Hawkesbury, ON K6A 2B8 CA
Tel: 613-632-1282
Fax: 613-632-2030
MID: XOTULSAF1123HAW
email: info@tulmar.com

Bill No:

Dart Aerospace
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7. Canada

Packing Slip No.

31793

Ship Date

4-Mar-09

Ship To:

Dart Aerospace
1270 Aberdeen Street
Att: Chantal Lavoie
Tel: 613-632-9577
Hawkesbury, ON K6A 1K7. Canada
613-632-9577

Order number	Sales order date	Account number	Account manager
22839	18-Feb-09	CDART100	Barney Bangs
PO number	Ship Via	PPD/COL	
PO00008208	Pick-Up		
Item No.	Quantity ordered	UOM	Qty Shipped/Returned
Description			Quantity on back order

8421-109	12	EA	12
Dart Blade Fold Kit - Pad #10/ Drawing No: (Ref B67-43001-35 Rev B1) DWG Rev:A Lot No: BATCH0000000005 Qty: 12			

8421-106	18	EA	18
Dart Blade Fold Kit - Pad #7/ Drawing No: (Ref B67-43001-69 Rev B1) DWG Rev:A Lot No: BATCH0000000004 Qty: 18			

Shipper

[Signature]

Date:

MAR 04 2009

Certificate of Conformance

☐ Not Applicable

I hereby certify that the items listed hereon have been inspected, tested and conform to all specifications and requirements detailed in the contract or purchase order. Objective evidence to support this statement is on file, and can be made available upon request.
If any questions or concerns, please contact QA Manager @ 613-632-1282 ext. 245.

Authorized Inspector

Date: 03/04/2009

E.F. Walter Inc.	<u>CERTIFICAT DE CONFORMITÉ</u> <u>CERTIFICATE OF COMPLIANCE</u>		Approved <u>JR</u> Date <u>1/3/02</u>
Revision # 0	Revision date: January 30, 2002	Doc # F.7.5.5.A	Page 1 of 1

Date : 07/15/2005

VENDU À
SOLD TO

6048

TULMAR SAFETY SYSTEMS INC.

1123 CAMERON STREET

HAWKESBURY ONT

K6A 2B8

FOURNISSEUR
VENDOR

E.F. WALTER INC.

5000 HICKMORE

ST. LAURENT, PQ

H4T 1K6

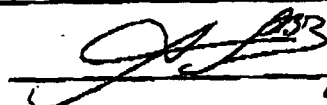
Commande / Order # 10280

Notre / Our Reference # 37736

Nous certifions par la présente que la totalité du matériel inscrit ci-dessous a été inspecté et vérifié et est conforme aux devis et aux normes mentionnés sur votre commande.

We hereby certify that all of the material listed below has been inspected and tested and conforms to the drawings and / or specifications stated on your purchase order.

Item	Quantité Quantity	Pièce # Part #	Description
742050004	10.00 SH		SC42 BLACK NEOPRENE UNTRIMMED 1/2" X 42" X 72" (NO SKIN) ASTM D1056 2A2
742012002	5.00 SH		SC42 BLACK NEOPRENE UNTRIMMED 1/8" X 42" X 72" (NO SKIN) ASTM D1056 2A2
			FLAME RESISTANCE
			SERVICE TEMP -40 DEG F TO +200 DEG F

Signé
Signed
 July 15, 2005

Eg #1637-001/01 (Cw)



J. ENNIS FABRICS LTD.

Wholesale Distributor of Textiles and Supplies

October 9, 2008

Fax To: Tulmar Safety Systems
Fax: 613-632-2036
Attention: Sandra Nadeau
Fax From: Sharon James

**EDMONTON
HEAD OFFICE**
12122 - 68 Street
Edmonton, AB T5B 1R1
Canada
Phone: (780) 474-5721

Certificate of Conformance

Re: PO 14881-00 for Oxford 7 Black

The goods shipped on P/O 14881-00 are as per sampled goods. Specification as follows:
As per mill documentation:

Oxford is in compliance with the following standards:

Width: Product is 58 Inches Wide.

Roll Size: Average Roll Length is 75 Yards.

Weight: Product Weight is 8.79 Ounces per Sq. Yd. /Product Weight is 10.94 oz per Lin. Yd

Content: 100% Nylon

Coating: Product has a Polyurethane Coating (approximately 0.65 oz/ Sq. Yd. (18.5g/sq.yd.))

CALGARY
2nd Floor, 337 - 17 Avenue SW
Calgary, AB T2S 0A5
Canada

Denier: Yarn is 420 Denier.

Thread Count: Construction is 62 x 38 Threads per Square Inch

Protective Finish: Product is Water Repellent.

Hydro Resist: AATCC 127 (Suter): Average 800 mm

Manufacture Date: 08/06/08

VANCOUVER
13911 Bridgeport Road
Richmond, BC V6V 1J6
Canada

Lot Number: 35896

Sincerely,
J. Ennis Fabrics Ltd.

S James

MONTREAL
9280 boulevard du Golf
Anjou, QC H1J 3A1
Canada

Sharon James
Product Development

English: 1-800-66-ENNIS

Fax: (780) 479-6135
www.jennisfabrics.com

Français: 1-888-66-ENNIS

TSS # 1495/14

NO. 355

J ENNIS FABRICS LTD

OCT. 9. 2008 1:09PM